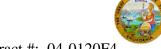
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William **Report No:** WIR-029292

Address: 333 Burma Road **Date Inspected:** 19-Mar-2013

City: Oakland, CA 94607

OSM Arrival Time: 1300 **Project Name:** SAS Superstructure **OSM Departure Time:** 1630 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV Contractor: American Bridge/Fluor Enterprises, a JV **Location:** On Site

CWI Name: CWI Present: Yes No N/A **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No **Weld Procedures Followed:** Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS: Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component:** Tower Electroslag Welds

Summary of Items Observed:

The Caltrans OSM Quality Assurance (QA) Inspector Art Peterson was present during the times noted above to perform ultrasonic inspection verification on Electroslag welds inside of the Tower. The purpose of the ultrasonic inspection was for the detection of planar indications utilizing both the pulse echo (PE) technique and the pitch and catch (PC) technique for further discontinuity evaluation in the middle half of the material thickness on electroslag welds where previous discontinuities were detected by the single pulse echo search unit. The data collected from utilizing the pitch and catch technique is for information only and the ultrasonic test (UT) inspection was performed as a joint inspection with ABF/JV Quality Control (QC) Smith Emery NDT personnel. The summary of the joint ultrasonic inspection performed on this date was as follows:

Tower Electroslag Weld Identification: S-042 150°

Electroslag Weld: Weld #L - Shear Plate -"B" side of weld tested only.

Type of Joint: T (60) mm thick weld.

From Y Location: (6600) mm of weld tested.

Results: (1) planar Indication with no planar height characteristics – PE Decibel rating (+15) / PC Decibel rating (+22).

Summary of Conversations:

Only general conversations with ABF/JV QC NDT personnel regarding the ultrasonic inspection utilizing the pulse echo and pitch and catch technique on Electroslag welds inside of the Tower on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

WELDING INSPECTION REPORT

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remedial efforts please contact Gary Thomas, 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Peterson,Art	Quality Assurance Inspector
Reviewed By:	Mertz,Robert	QA Reviewer